	er ID 125129 er 07, 2014 10:36:07 AM		*125	129*							Pag	e 1
Item ID: Revision ID: Item Name:	D3459-3 Float Step Mounting Plate		Accept	*N900	040	100	ገ*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	10/06/14 Start Qty: 6.00 Req'd Qty: 6.00	* *		Cust Item 1 Customer:	ID:							
Approvals:	Process Plan: MLT	Date: 14-10-	08 Tooling:	D	ate:			Run	Start	*N	R1*	A)-
	QC:	Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	#
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3459	Rev A											
*100 *100*	FLOW WATER JET	,	0.00				6		0		DAS 23 9-89	11/11/11
Waterjet FLOW CNC Waterj	Memo 1-Cut as	s per Dwg D3459	0.00									
061.18824	Dwg Re Prog Re	v: A rr if necessary										
		HOLES ARE PROGRAMMI ALLY ON DRILL PRESS	ED SMALER,OPEN TO .25	7"~								
110	QC2- Inspect parts of	ff machine FAI/FAIB	0.00	,			/.				DAS 23 9-89	W.o.
11 0 ^{QC}	Memo		0.00)			_[4-11-1

Quality Control

DQA:		_ Date:			•								7	TQAR [*]
OA Clasadi		Data			WORK ORDER NON	-C	ONFO	RMANCE / U		Morte C	and an example	adaka aulu		AEROSPACE
QA Closed:		Date:					ř			vvork C	raer u	odate only	Щ	·
Work Orde	er:			•	DISPOSITION				AGAINST	DEPART	DEPARTMENT/PROCESS			
					Rework]]	Skid-tube Crosstube			Water Jet			Engineering
Part N	lo.				Scrap		İ	Machining	Small Fab		Pro	d. Eng. Coor.	\vdash	Quality
					Use-as-is	1	Thern	noforming	Finishing	R		re/Packaging	-	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier		
										1		<u> </u>		·
Root		.	٥.	Desci	ription of work order update	ı	Initial		tion		gn &			
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	ription		ate	Verificatio	n	QC Inspector
Design									•					•
Doc/Data	_					ļ							İ	
Equip/Tooling														
Handling/Pre Material	-			:]								
Operator	_												- 1	
Offset/Setup														
Process													İ	
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Unapproved								, i						
						FAI	ULT CAT	EGORY						
Landir	ng Gear				General		_							
	Bending				Bend		Folio/P	rogram		Outs	ide Dim	ensions		Pressure/Forced
	Centre 1	Not Conce	ntric		BOM/Route		Grain			Over	/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part	Incorrec	ct .		Temperature/Cure
	Crimp/K	ink/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	Part	Lost/Mi	ssing		Weld
	Cuffs				Contamination			ions Incomplete/U	Jnclear	Part	Moved		∐'	Wrong Stock Pulled
	Crushin	_		-	Countersink	<u> </u>	•	ned/off center		_	ioned W	-	_	
	Heat Tre			-	Cut Too Short	\vdash	Mislabe		Ĺ	Powe	er Loss/S	Surge		Other
	 _	on Strip in	Tube		Drawing		Misreac							
	Marks/0				Drill Holes		Off-set			<u> </u>				
		Sequence			Finish		1	Calibration						
	Wave/T	wist in Tub	ne e		Fit/Function		Out of S	equence						

Work Ord Tuesday, Octobe				*125	5129*							Page 2
Item ID: Revision ID:	D3459-3			Accept	*N900	040	100)* s		Start		S1*
Item Name:	Float Step Mo	ounting Plate								Stop	*N	S2*
Start Date: Required Date: Reference:	10/06/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:						
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:	_	R		Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Date:					Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
120		QC8- Inspect parts - seco	ond check	0.00					,			DAS
120 QC Quality Control		Memo		0.00				(6))			38
130		Identify as per dwg & St	ock Location:WAO3	0.00				1 /				DI Icela
130 Packaging Packaging		Memo *** STOCK	IN STEP CELL***	0.00				bx			/	DL 14/11,

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

DQA:		_ Date:			—									
O A Classide		Data			WORK ORDER NON	-CC	ONFO	RMANCE / U		4 / 3 - 1 3	_	AEROSPACE		
QA Closed:		Date:					·			Vork Order u	odate only			
Work Orde	er:				DISPOSITION				AGAINST [T DEPARTMENT/PROCESS				
		-			Rework	1	Skid-tube Crosstube				Water Jet	\neg	Engineering	
Part N	lo.			٠	Scrap	i i		Machining	Small Fab	Pro	d. Eng. Coor.	ㅓ	Quality	
					Use-as-is	1		noforming	Finishing		re/Packaging	ヿ	Other	
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier			
		1	·			لــــ	*** 1	T		l s: 0				
Root	D-4-	Char	٥,	Desci	ription of work order update	l	Initial	Act		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	1	QC Inspector	
Design														
Doc/Data												ŀ		
Equip/Tooling											:			
Handling/Pre														
Material Operator												- 1		
Offset/Setup												1		
Process														
Supplier					!									
Training														
Transport														
Unapproved						ŀ						Ī		
		•		<u> </u>		FAL	JLT CAT	EGORY		<u> </u>				
Landi	ng Gear				General									
	Bending			,	Bend		Folio/P	rogram		Outside Dim	ensions	ال	Pressure/Forced	
	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	<u></u> :	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	rt [╝	Temperature/Cure	
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	Part Lost/Mi	ssing	\	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	Part Moved		\	Wrong Stock Pulled	
	Crushing				Countersink	_	_	ned/off center		Positioned V	/rong _			
	Heat Trea				Cut Too Short		Mislabe	led		Power Loss/:	Surge		Other	
	· ·	n Strip in	Tube		Drawing		Misread	l						
	Marks/Cl				Drill Holes	-	Off-set			<u></u>				
	Turning S				Finish	-		Calibration						
	Wave/Twist in Tube				Fit/Function		Out of S	equence						

Picklist Print

Tuesday, October 07, 2014 10:36:06 AM

Work Order ID: 125129

125129

Parent Item:

D3459-3

D3459-3

Parent Item Name: Float Step Mounting Plate

Start Date: 10/06/14

Required Date: 10/06/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments.

IPP Rev: A New Issue 06-01-06 JLM

IPP Rev: B waterjet 06-12-06 ec

Communities.	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M6061T6B0.187X04.00 0		Purchased	No			110	f	53.0168	0.347	3		DAS
M6061T6	BO 187	X04 00	/ 0						**			23 9-89 (4-11-

M6061168018/X04 000

6061-T6 Bar .187 x 4.00

Location	Loc Qty	Loc Code	
MAT051	53.016842		
m128265	16.116842		128265
m129411	36.9		

DQA:		Date:			<u> </u>								T A A C
2 A Cl I		D-4			WORK ORDER NON	-C(ONFO	RMANCE / U				_	AEROSPACE
QA Closed:		Date:					Γ			Vork Order up	date only		
Work Orde	r:				DISPOSITION				AGAINST [EPARTMENT,	/PROCESS		
					Rework	1	•	Skid-tube	Crosstube	1 .	Water Jet	\neg	Engineering
Part N	0.				Scrap		ŀ	Machining	Small Fab	Pro	d. Eng. Coor.	\dashv	Quality
					Use-as-is	1 1	1	noforming	Finishing	_	re/Packaging	ᅦ	Other
NCR N	0				Suspected Unapproved]		Large Fab	Composite		Supplier		
Root	_	1	T	Desci	ription of work order update	 	Initial	Acti	ion	Sign &			
Cause	Date	Step	Qty	Desci	or non-conformance	l	nief Eng	Descri		Date	Verification	.	QC Inspector
Design	Date	3.Cp	Q.C.y		or non comormance	Cit	iler Ling	Descri	iption	Date	vermeation	+	QC IIIspector
Doc/Data													
Equip/Tooling													
Handling/Pre	\dashv												
Material												-	
Operator													
Offset/Setup													
Process										İ			
Supplier													
Training													
Transport													
Jnapproved													
					1	FAL	ULT CAT	EGORY					
Landing	g Gear				General				<u></u>		_		-
L	Bending				Bend		Folio/P	rogram	L	Outside Dim	ensions	F	Pressure/Forced
<u> </u>	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	{5	Set-up
L	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred	t _	T	Temperature/Cure
L	Crimp/Kir	nk/Ripple	/Wave	-	Burrs		1	on Incomplete/Un	· -	Part Lost/Mi	ssing	\ل	Weld
_	Cuffs				Contamination		1	ions Incomplete/U	nclear	Part Moved	Ĺ	\	Wrong Stock Pulled
_	Crushing			-	Countersink		1	ned/off center	<u> </u>	Positioned W			
-	Heat Trea				Cut Too Short	Щ	Mislabe			Power Loss/S	Surge	10	Other
-	Inspection	•	Tube	\vdash	Drawing	H	Misread	i					· · · · · · · · · · · · · · · · · · ·
-	Marks/Ch			\vdash	Drill Holes	\vdash	Off-set						
-	Turning S				Finish	\square	l	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of S	equence					

DART AEROSPACE LTD	Work Order:	125129
Description: Float Step Mounting Plate	Part Number:	D3459-3
Inspection Dwg: D3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.259			U	Jumos
2.715	+/-0.010	2.715	_		v	JAPA
0.403	+/-0.010	0.403	_		V	
R0.125	+/-0.010	0.152	_		RG	
R0.063	+/-0.010	0.063	_		RG-	
0.839	+/-0.010	0.839"	_		V	
0.188	+/-0.010	0.187	<u> </u>		· /	
			<u>.</u>			
	DAS					

Measured by: 9-89

DAS

Audited by: 38
O-PO

Date: NOV 1 1 2014

Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	Approved
В	07.09.06	Dimensions added	KJ/JLM	13
	***************************************		1 KO/OLIVI CALL	a

